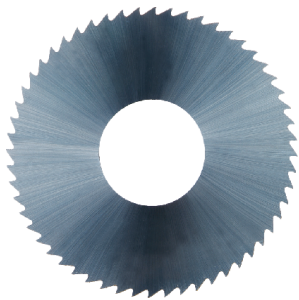
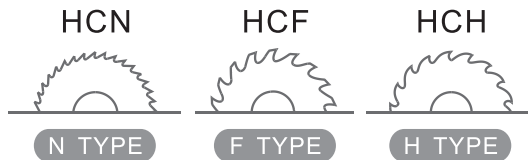


# 高速鋼鋸片- 中齒數(56T/72T)細齒數(100T)

## HIGH SPEED STEEL SLITTINGSAW-Middle Teeth(56T/72T)/Fine Teeth(100T)



※HCH：鉤齒型鋸片→依需求生產！  
 ※HCH Type is dependent on demand.



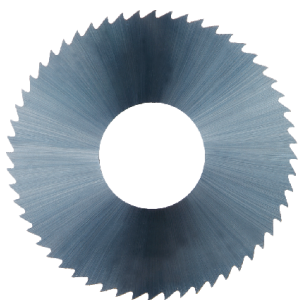
Milling Table 63

外徑 D	厚度 H	內徑 d	齒數 T	HCN 訂購編號 HCN Order No.	HCF 訂購編號 HCF Order No.
70#30	0.25	25.4	100	HCN-07000-0025-100-2540	HCF-07000-0025-100-2540
70#29	0.29	25.4	100	HCN-07000-0029-100-2540	HCF-07000-0029-100-2540
70#28	0.32	25.4	100	HCN-07000-0032-100-2540	HCF-07000-0032-100-2540
70#27	0.36	25.4	100	HCN-07000-0036-100-2540	HCF-07000-0036-100-2540
70#26	0.40	25.4	100	HCN-07000-0040-100-2540	HCF-07000-0040-100-2540
70#25	0.45	25.4	100	HCN-07000-0045-100-2540	HCF-07000-0045-100-2540
70#24	0.51	25.4	100	HCN-07000-0051-100-2540	HCF-07000-0051-100-2540
70#23	0.57	25.4	100	HCN-07000-0057-100-2540	HCF-07000-0057-100-2540
70#22	0.64	25.4	100	HCN-07000-0064-100-2540	HCF-07000-0064-100-2540
70#21	0.72	25.4	100	HCN-07000-0072-100-2540	HCF-07000-0072-100-2540
70#20	0.81	25.4	100	HCN-07000-0081-100-2540	HCF-07000-0081-100-2540
70#19	0.91	25.4	100	HCN-07000-0091-100-2540	HCF-07000-0091-100-2540
70#18	1.02	25.4	100	HCN-07000-0102-100-2540	HCF-07000-0102-100-2540
70#17	1.15	25.4	100	HCN-07000-0115-100-2540	HCF-07000-0115-100-2540
70#16	1.29	25.4	100	HCN-07000-0129-100-2540	HCF-07000-0129-100-2540
70#15	1.45	25.4	100	HCN-07000-0145-100-2540	HCF-07000-0145-100-2540
70#14	1.63	25.4	100	HCN-07000-0163-100-2540	HCF-07000-0163-100-2540
70#13	1.83	25.4	100	HCN-07000-0183-100-2540	HCF-07000-0183-100-2540
70#12	2.05	25.4	100	HCN-07000-0205-100-2540	HCF-07000-0205-100-2540

外徑 D	厚度 H	內徑 d	齒數 T	HCN 訂購編號 HCN Order No.	HCF 訂購編號 HCF Order No.
75	0.3	25.4	72	HCN-07500-0030-072-2540	HCF-07500-0030-072-2540
75	0.4	25.4	72	HCN-07500-0040-072-2540	HCF-07500-0040-072-2540
75	0.5	25.4	72	HCN-07500-0050-072-2540	HCF-07500-0050-072-2540
75	0.6	25.4	72	HCN-07500-0060-072-2540	HCF-07500-0060-072-2540
75	0.7	25.4	72	HCN-07500-0070-072-2540	HCF-07500-0070-072-2540
75	0.8	25.4	72	HCN-07500-0080-072-2540	HCF-07500-0080-072-2540
75	0.9	25.4	72	HCN-07500-0090-072-2540	HCF-07500-0090-072-2540
75	1.0	25.4	72	HCN-07500-0100-072-2540	HCF-07500-0100-072-2540
75	1.1	25.4	56	HCN-07500-0110-056-2540	HCF-07500-0110-056-2540
75	1.2	25.4	56	HCN-07500-0120-056-2540	HCF-07500-0120-056-2540
75	1.3	25.4	56	HCN-07500-0130-056-2540	HCF-07500-0130-056-2540
75	1.4	25.4	56	HCN-07500-0140-056-2540	HCF-07500-0140-056-2540
75	1.5	25.4	56	HCN-07500-0150-056-2540	HCF-07500-0150-056-2540
75	1.6	25.4	56	HCN-07500-0160-056-2540	HCF-07500-0160-056-2540
75	1.7	25.4	56	HCN-07500-0170-056-2540	HCF-07500-0170-056-2540
75	1.8	25.4	56	HCN-07500-0180-056-2540	HCF-07500-0180-056-2540
75	1.9	25.4	56	HCN-07500-0190-056-2540	HCF-07500-0190-056-2540
75	2.0	25.4	56	HCN-07500-0200-056-2540	HCF-07500-0200-056-2540
75	2.5	25.4	56	HCN-07500-0250-056-2540	HCF-07500-0250-056-2540
75	3.0	25.4	56	HCN-07500-0300-056-2540	HCF-07500-0300-056-2540

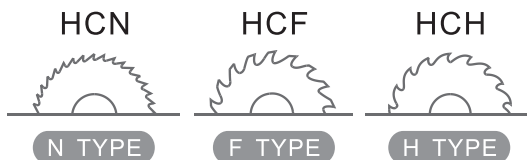
# 高速鋼鋸片- 中齒數(56T/72T)/細齒數(100T)

## HIGH SPEED STEEL SLITTING SAWS-Middle Teeth(56T/72T)/Fine Teeth(100T)



※HCH：鈎齒型鋸片→依需求生產！

※HCH Type is dependent on demand.



Milling Table 63

外徑 D	厚度 H	內徑 d	齒數 T	HCN訂購編號 HCN Order No.	HCF 訂購編號 HCF Order No.
100	0.5	25.4	72	HCN-10000-0050-072-2540	HCF-10000-0050-072-2540
100	0.6	25.4	72	HCN-10000-0060-072-2540	HCF-10000-0060-072-2540
100	0.7	25.4	72	HCN-10000-0070-072-2540	HCF-10000-0070-072-2540
100	0.8	25.4	72	HCN-10000-0080-072-2540	HCF-10000-0080-072-2540
100	0.9	25.4	72	HCN-10000-0090-072-2540	HCF-10000-0090-072-2540
100	1.0	25.4	72	HCN-10000-0100-072-2540	HCF-10000-0100-072-2540
100	1.1	25.4	56	HCN-10000-0110-056-2540	HCF-10000-0110-056-2540
100	1.2	25.4	56	HCN-10000-0120-056-2540	HCF-10000-0120-056-2540
100	1.3	25.4	56	HCN-10000-0130-056-2540	HCF-10000-0130-056-2540
100	1.4	25.4	56	HCN-10000-0140-056-2540	HCF-10000-0140-056-2540
100	1.5	25.4	56	HCN-10000-0150-056-2540	HCF-10000-0150-056-2540
100	1.6	25.4	56	HCN-10000-0160-056-2540	HCF-10000-0160-056-2540
100	1.7	25.4	56	HCN-10000-0170-056-2540	HCF-10000-0170-056-2540
100	1.8	25.4	56	HCN-10000-0180-056-2540	HCF-10000-0180-056-2540
100	1.9	25.4	56	HCN-10000-0190-056-2540	HCF-10000-0190-056-2540
100	2.0	25.4	56	HCN-10000-0200-056-2540	HCF-10000-0200-056-2540
100	2.5	25.4	56	HCN-10000-0250-056-2540	HCF-10000-0250-056-2540
100	3.0	25.4	56	HCN-10000-0300-056-2540	HCF-10000-0300-056-2540
外徑 D	厚度 H	內徑 d	齒數 T	HCN 訂購編號 HCN Order No.	HCF 訂購編號 HCF Order No.
125	0.8	25.4	100	HCN-12500-0080-100-2540	HCF-12500-0080-100-2540
125	1.0	25.4	100	HCN-12500-0100-100-2540	HCF-12500-0100-100-2540
125	1.2	25.4	72	HCN-12500-0120-072-2540	HCF-12500-0120-072-2540
125	1.5	25.4	72	HCN-12500-0150-072-2540	HCF-12500-0150-072-2540
125	2.0	25.4	72	HCN-12500-0200-072-2540	HCF-12500-0200-072-2540
125	2.5	25.4	72	HCN-12500-0250-072-2540	HCF-12500-0250-072-2540
125	3.0	25.4	72	HCN-12500-0300-072-2540	HCF-12500-0300-072-2540
外徑 D	厚度 H	內徑 d	齒數 T	HCN 訂購編號 HCN Order No.	HCF 訂購編號 HCF Order No.
150	1.0	25.4	100	HCN-15000-0100-100-2540	HCF-15000-0100-100-2540
150	1.2	25.4	100	HCN-15000-0120-100-2540	HCF-15000-0120-100-2540
150	1.6	25.4	100	HCN-15000-0160-100-2540	HCF-15000-0160-100-2540
150	2.0	25.4	100	HCN-15000-0200-100-2540	HCF-15000-0200-100-2540
150	2.5	25.4	100	HCN-15000-0250-100-2540	HCF-15000-0250-100-2540
150	3.0	25.4	100	HCN-15000-0300-100-2540	HCF-15000-0300-100-2540
150	4.0	25.4	100	HCN-15000-0400-100-2540	HCF-15000-0400-100-2540
150	5.0	25.4	100	HCN-15000-0500-100-2540	HCF-15000-0500-100-2540

**Table 62 鎢鋼鋸片 切削條件表**

**MICRO GRAIN CARBIDE SLITTING SAWS-MILLING CONDITION TABLE**

加工材質 WORKING MATERIAL	碳素鋼/合金鋼 CARBON STEEL / ALLOY STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		調質鋼 HARDENED STEEL		銅, 鋁 COPPER ALUMINUM		不銹鋼 STAINLESS STEEL		鑄鐵 CAST IRON	
MATERIAL CODE	(S45C,S50C,SCM)		(SCM,SKT,SKD)		(SCM,SKT,SKD)		(SKT,SKD)		—		(SUS304)		FC/FCD	
HARDNESS GRADE	HRC<20		HRC20~30		HRC30~40		HRC45~以上		—		—		—	
切削速度 Vc	68M/min		59M/min		45M/min		28M/min		148M/min		59M/min		68M/min	
外徑 DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
30MM	740	280	630	240	470	180	310	120	1590	620	630	240	740	280
45MM	490	280	420	240	310	180	210	120	1060	620	420	240	490	220
70MM	310	330	270	280	200	210	130	140	680	710	270	280	310	330
75MM	290	330	250	280	190	210	120	140	630	710	250	280	290	330
100MM	220	370	190	320	140	230	90	150	470	800	190	320	220	370
125MM	170	360	150	310	110	220	70	140	380	790	150	310	170	360

**Table 63 高速鋼(高鈷鋼)鋸片 切削條件表**

**HSS & HSS-Co SLITTING SAWS-MILLING CONDITION TABLE**

加工材質 WORKING MATERIAL	碳素鋼/合金鋼 CARBON STEEL / ALLOY STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		調質鋼 HARDENED STEEL		銅, 鋁 COPPER ALUMINUM		不銹鋼 STAINLESS STEEL		鑄鐵 CAST IRON	
MATERIAL CODE	(S45C,S50C,SCM)		(SCM,SKT,SKD)		(SCM,SKT,SKD)		(SKT,SKD)		—		(SUS304)		FC/FCD	
HARDNESS GRADE	HRC<20		HRC20~30		HRC30~40		HRC45~以上		—		—		—	
切削速度 Vc	48M/min		41M/min		32M/min		20M/min		104M/min		41M/min		48M/min	
外徑 DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
30MM	520	200	440	170	330	130	220	80	1110	430	440	170	520	200
45MM	340	230	290	170	220	130	150	80	740	430	290	170	340	150
70MM	220	230	190	200	140	150	90	100	480	500	190	200	220	230
75MM	200	260	175	200	130	150	80	100	440	500	175	200	200	230
100MM	150	250	130	220	100	160	60	105	330	560	130	220	150	260
125MM	120	250	105	220	80	150	50	100	270	550	105	220	120	252

以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。

These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.